

Work Order ID 52911

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Item ID: D2573

Revision ID: E

Item Name: Saddle, Aft Out 205

Start Date: 10/19/09 Start Qty: 8.00

Required Date: 11/02/09 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan: *PL*

Date: *09-10-19*

Tooling:

Date:

QC:

Date:

SPC (Y/N):




Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2573	Rev E								
100		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program Batch No. <u>52901</u> Double check by: <u>AK</u> <input type="checkbox"/> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp								
110		0.00							
	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine keyway as per dwg D2573 & D2574								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

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Item ID: D2573
Revision ID: E
Item Name: Saddle, Aft Out 205

Accept

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 8.00

Required Date: 11/02/09 Req'd Qty: 8.00

Cust Item ID:




Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	H.A 09/10/26			8	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BR 09-10-27			8			
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 10:30am FINISH TIME: 11:00am	0.00 0.00	M112260 7 JU 09/10/27			XC	0		

COVEN TEMPERATURE: 320F

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Item ID: D2573
Revision ID: E
Item Name: Saddle, Aft Out 205

Accept

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 8.00
Required Date: 11/02/09 Req'd Qty: 8.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

09-10-27

8



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

09/10/28 (8)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09-10-28

MF

09-10-28

Picklist Print

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Work Order ID: 52911

Parent Item: D2573RevE

Parent Item Name: Saddle, Aft Out 205



Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007RevB  Saddle Billet		Manufactured	No			100	Each	0.0000	8.0000 			

B 46412 x8 28 09/10/22

DART AEROSPACE LTD	Work Order:	52911
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.443	.439	.439	.440		
B	1.745	1.755		1.750	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.499	3.499		
D	1.745	1.755		1.750	1.749	1.749	1.749		
E	7.990	8.010		8.000	8.002	8.002	8.003		
F	0.490	0.510		.503	.504	.502	.503		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.372		
I	0.490	0.510		.498	.501	.502	.502		
J	1.174	1.184		1.180	1.177	1.177	1.177		
K	0.558	0.578		.567	.567	.569	.568		
L	1.174	1.184		1.180	1.177	1.177	1.177		
M	1.365	1.375		1.370	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.499	2.499	2.499		
O	4.119	4.129		4.124	4.123	4.123	4.123		
P	0.115	0.135		.121	.122	.124	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.249	.257	.249		
S	0.115	0.135		.118	.117	.124	.121		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.235	3.228	3.230	3.230		
V	0.230	0.250		.237	.230	.239	.238		
W	0.115	0.135		.120	.115	.121	.122		
X	0.308	0.313		.310	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.369	.372	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.634	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.240	.245	.245		
AE	1.500	1.520		1.514	1.516	1.507	1.511		
AF	0.115	0.135		.135	.125	.125	.130		
AG	0.240	0.280		.260	.271	.273	.275		
AH	0.240	0.260		.250	.242	.250	.249		
AI	2.000	2.020		2.004	2.005	2.000	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>SS</i>	Audited by: <i>HA</i>
Date: <i>09/09/23</i>	Date: <i>09/10/26</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443		.440	.439	.440	.439		
B	1.745	1.755		1.749	1.749	1.750	1.749		
C	3.495	3.505		3.499	3.499	3.500	3.499		
D	1.745	1.755		1.749	1.749	1.750	1.749		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.503	.504	.503	.502		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.502	.500	.502	.503		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		.569	.567	.567	.568		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.368	1.368	1.369	1.369		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	4.119	4.129		4.123	4.122	4.123	4.124		
P	0.115	0.135		.122	.121	.123	.121		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.250	.250	.250		
S	0.115	0.135		.124	.124	.122	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.228	3.228	3.230		
V	0.230	0.250		.239	.239	.238	.238		
W	0.115	0.135		.122	.120	.120	.120		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.366	.367	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.635	.635	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.244	.244	.244		
AE	1.500	1.520		1.510	1.511	1.512	1.512		
AF	0.115	0.135		.122	.127	.128	.124		
AG	0.240	0.280		.270	.274	.277	.273		
AH	0.240	0.260		.251	.249	.249	.250		
AI	2.000	2.020		2.006	2.000	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>ant</i>
Date:	09/10/25

Audited by:	<i>M.A</i>
Date:	09/10/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>